

ASAP please

Dart Aerospace Ltd.

Date: Thursday, 10/5/2006 3:35:27 PM
 -User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING TIDY
 Job Number : 28878
 Estimate Number : 11381
 P.O. Number : N/A Part Number : D32153
 This Issue : 10/5/2006 S.O. No. : N/A Drawing Number : D3215 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 28144 Material : N/A
 Due Date : 10/18/2006 Qty: 50 Um: Each
 Written By : HA
 Checked & Approved By : HA 061005
 Comment : Est. A04.01.06 New issue KJ/RF
 Est Rev:B Now on Waterjet 06-07-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.3545 sf(s)
 5052-H32 .040 Sheet
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040)
 Identify for D3215-3A
 Batch: M101875

SAD 06:10:07

50

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3215
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

SAD 06:10:07

50

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:10:07

50

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Job-10-10 (51)
countal.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/5/2006 3:35:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 28878

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.4200 sf(s)

5052-H32 .040 Sheet

Batch: M101875

MF. 06/10/10

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut blank: 2.130" x 0.530"

MF. 06/10/10

(S)

2-Deburr

MF. 06/10/10

(S)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/10 (S)

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/10/10 (S)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-10-10 (S)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M18838

Identify as D3215-3

Grind flush

GPL 06-10-11

(S)

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

DA 06/10/11 (S)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/18/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/5/2006 3:35:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 28878

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 06 10 11 (51)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 06 10 11 (51)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 206/10/12 (51)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ID + sticker

C 206/10/12 (51)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 06/10/12 (52)

Job Completion



W 06.10.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

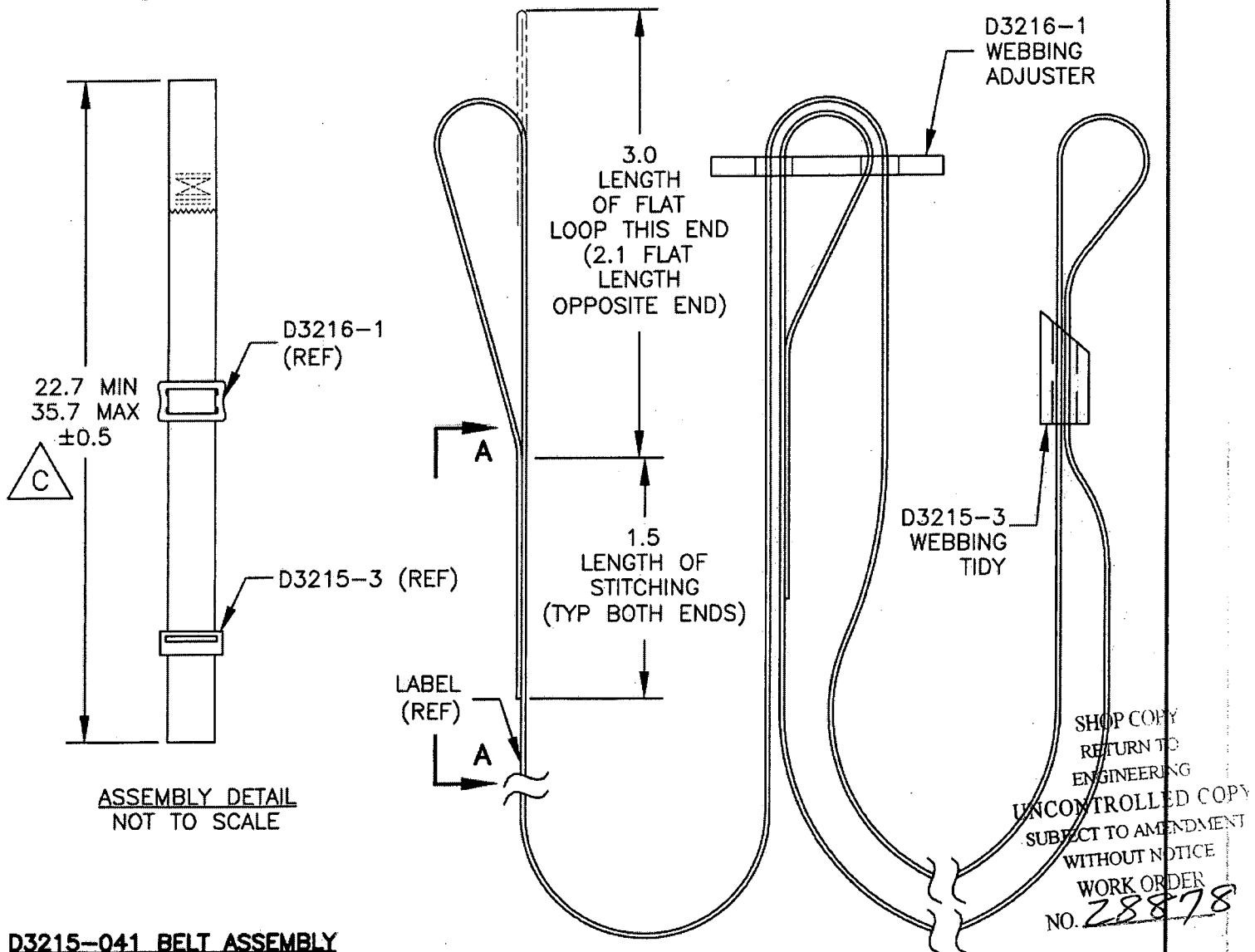
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	OP	DRAWN BY	OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3215	REV. C SHEET 1 OF 3
DATE	04.03.05			TITLE BELT ASSEMBLY	SCALE NTS
A	03.09.19			NEW ISSUE	
B	04.01.12			AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05			REDUCE LENGTH; CLARIFY STITCHING	

RELEASED
04.03.08



D3215-041 BELT ASSEMBLY

- MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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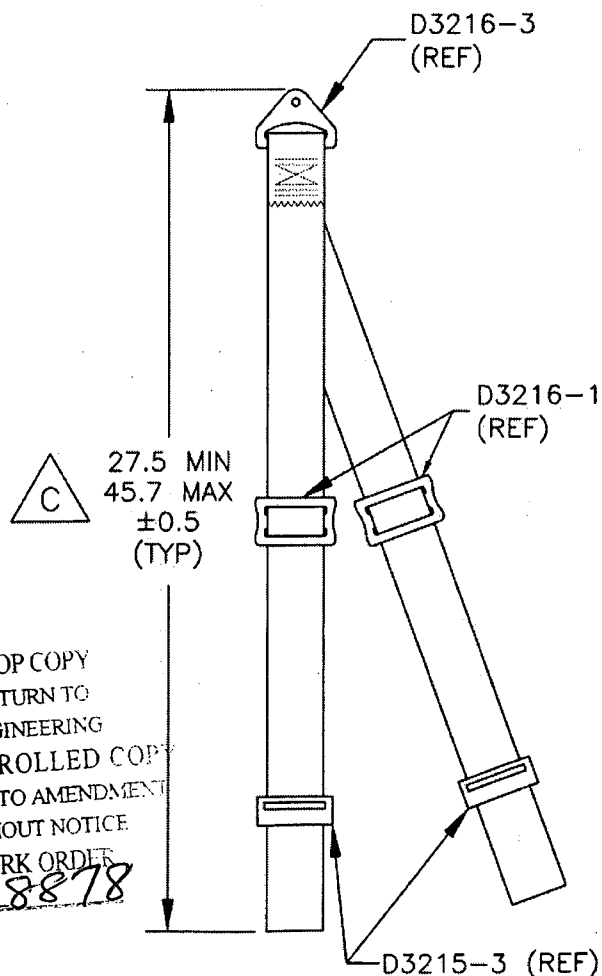
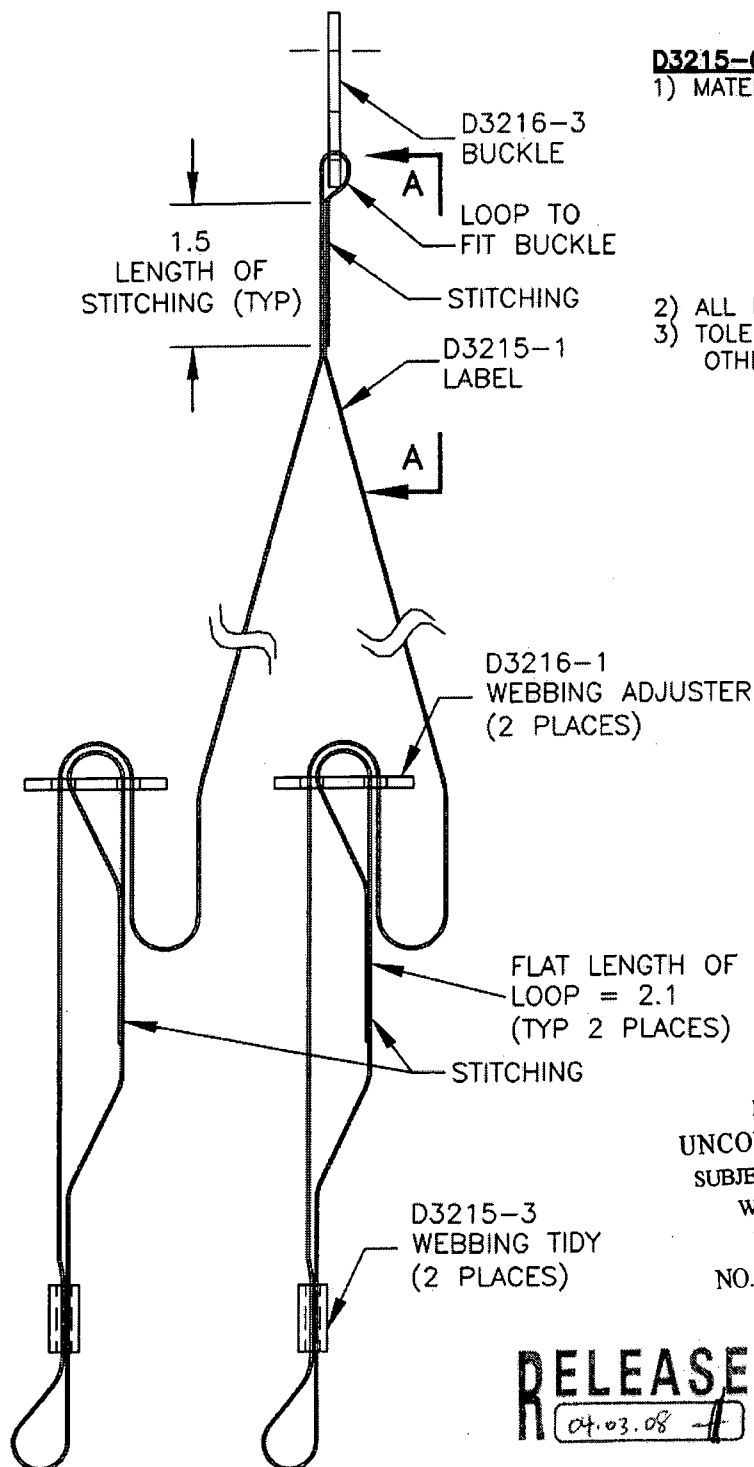
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK
BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3,
TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28878

RELEASED
04.03.08

ASSEMBLY DETAIL
NOT TO SCALE

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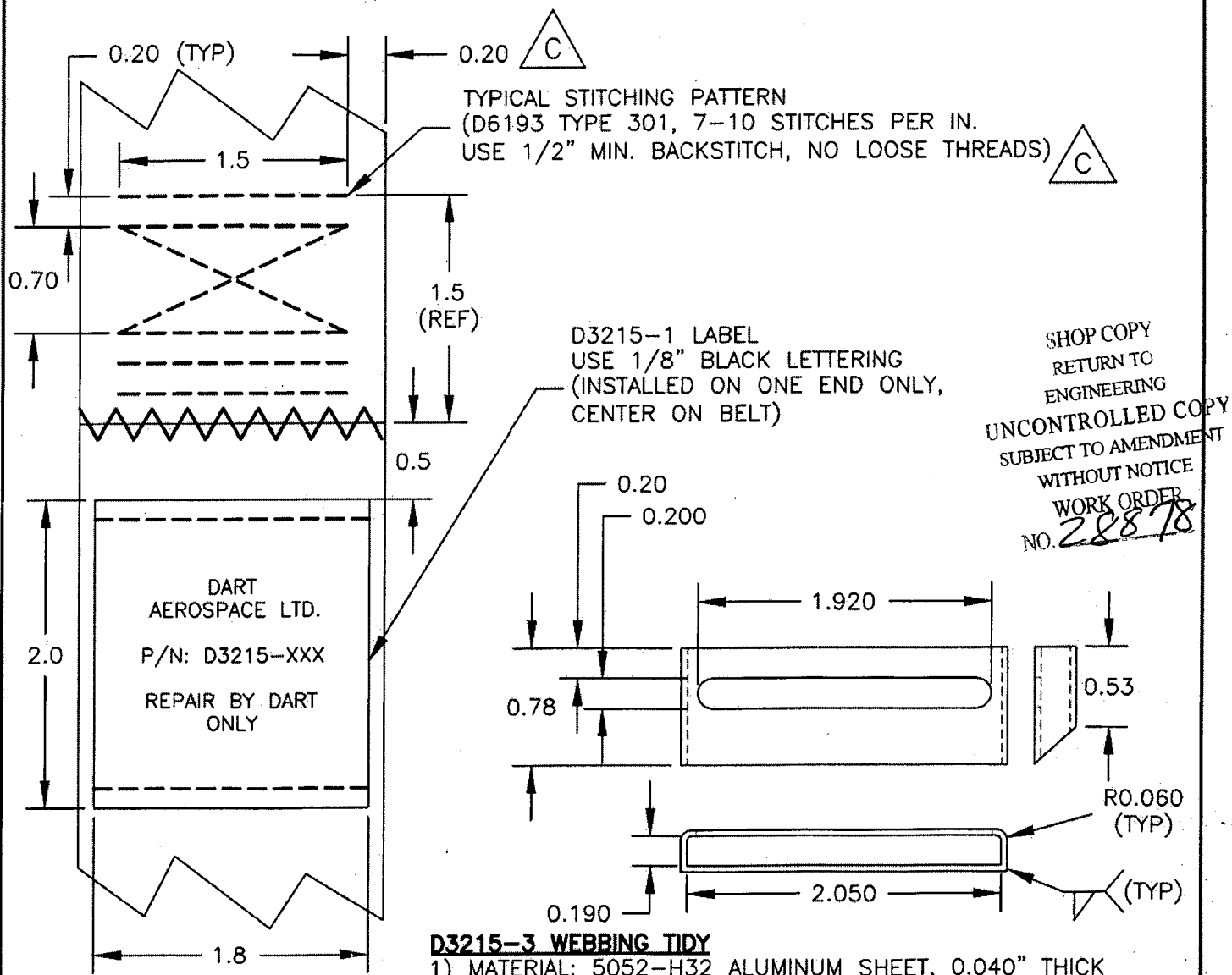
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DESIGN 49	DRAWN BY 49	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05		TITLE HARNESS ASSEMBLY	SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



RELEASED
04.03.08

D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

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